

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011515**Date Inspected:** 09-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: Zhu zhong hai
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: Yes No N/A
Approved WPS: Yes No N/A
Delayed / Cancelled: Yes No N/A

Bridge No: 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

OUTSIDE SHOP

FCAW welding of weld joint 2G-164 located on PCMK FB027-007 of 9DW welder is identified as 204730.ZPMC QC is identified as Mr.Li ping . The welding variables recorded by QC appeared to Comply with the WPS-B-T-2232-TC-U4b-F-1.

FCAW welding of weld joint 2F-030 located on PCMK SSD13-PP84 of 9EW welder is identified as 204730. ZPMC QC is identified as Mr. Li ping. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2132-3.

BAY#14

This QA inspector call to perform MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector found following issue, while doing Visual testing(VT). The notification no is 005028.

CA068-060- welding not done on that location

CA067-109- Spatter, Arc strike found

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

CA074-100- Arc strike found

CA073-069,113- Undercut and Porosity found

CA059-083- Notch, undercut on weld found

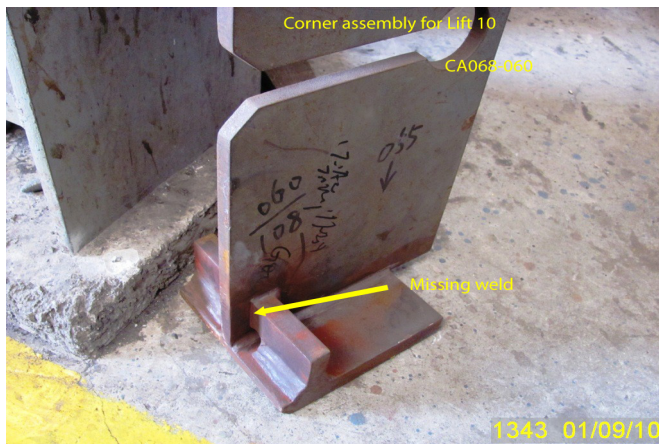
This informed to ZPMC QC Mr.Li Ming yang, he told ZPMC cancelled this notification, re inspect and send re notification.

BAY#19

FCAW welding of weld joint 2G-067 located on PCMK SB008-038 of Lift 6 welder is identified as 062588.

ZPMC QC is identified as Mr. Zheng cheng. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2232-TC-U4b-F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By:	Kumar, Chadra	Quality Assurance Inspector
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Reviewed By:	Patterson, Rodney	QA Reviewer
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